



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

P.
D3690-1

Job Sheet 168641



Part No: D3690-1

Job Qty: 3 ea

Part Name: Glareshield



Part Weight: 0 lbs

Job Created: 11/20/17

Due Date: 12/22/17

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Mario Poulin

Description:

Note: DWG REV C IPP Rev A New Issue 08/04/28 DL verified by:DD IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec IPP Rev:C 08-10-07 revC as per dwg DD verified by:EC Ipp Rev. D Add Step 115 Dry Material 10/04/21 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	3 pcs		12/22/17	0.00	0.00	Purchasing		AT 18/02/105
140	Packaging	3 pcs		12/22/17	0.00	0.00	Packaging2		AT 18/02/105
150	QC	3 pcs		12/22/17	0.00	0.00	QC6		
170	Packaging	3 pcs		12/22/17	0.00	0.00	Packaging3		
180	QC21-SA	3 Ea		12/22/17	0.00	0.00	QC21		

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

PO 038451
NOV 22 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D3690-1P	3	0	0	0
	MLEXS.093-F6006-02	79	474	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 4:57 PM dart.poulin.mario

SCRAP
P.T.O.

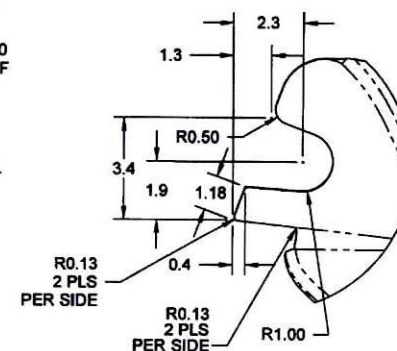
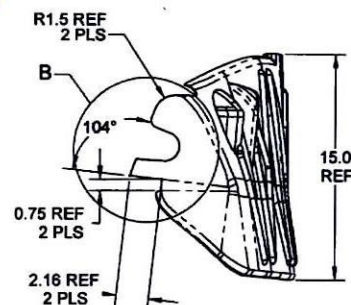
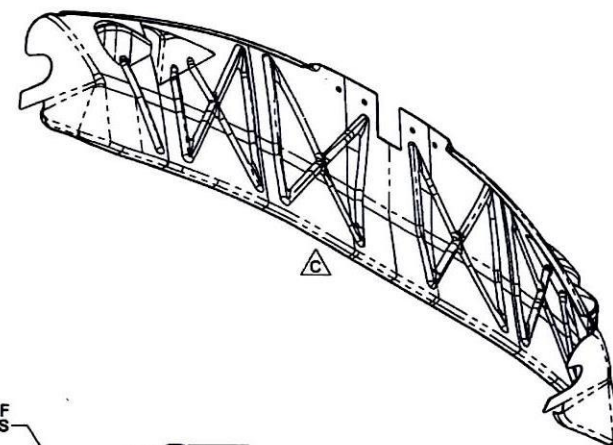
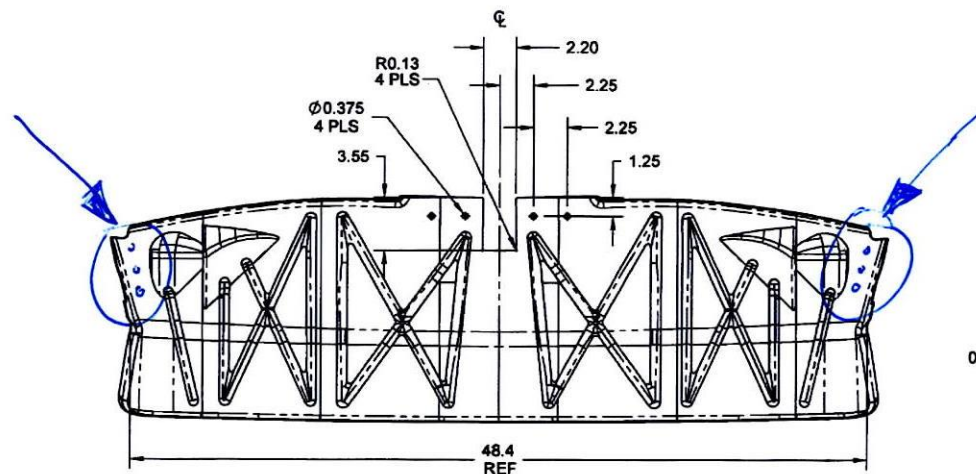
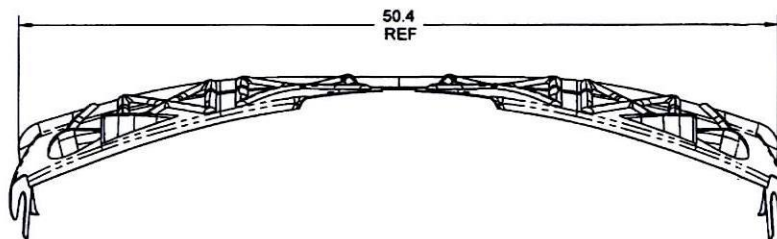
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																				
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																				
Description Work Order Deviation		Disposition		Completed By																																				
 S039122 Glareshield		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Lead hand / Supervisor Approval Verification																																				
PART NO: D3690 – 1 Original Serial #: S039122 Revision: Operation: Purchasing Change No:		Mfg Date: 02/05/18 Job No: 168641		QC / QA Coordinator Approval																																				
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">☐ No Re-verification</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">☐ Operator</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">☐ Offset/Setup</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">☐ Supplier</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">☐ Training</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">☐ Use for Testing</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">☐ Poor Information</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">☐ Rushing</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">☐ Product Improvement</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">☐ Process Improvement</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">☐ Manufacturing Process</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">☐ Past Due</td></tr> </table>		Environment ☐	☐ No Re-verification	Design ☐	☐ Operator	Doc/Data ☐	☐ Offset/Setup	Equip/Tooling ☐	☐ Supplier	Handling/Pre ☐	☐ Training	Material ☐	☐ Use for Testing	Internal Transport ☐	☐ Poor Information	Tribal Knowledge ☐	☐ Rushing	LOA ☐	☐ Product Improvement	Substation ☐	☐ Process Improvement	Past Expiry Date ☐	☐ Manufacturing Process	Misidentified ☐	☐ Past Due	<table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Crushing</td> <td style="border: none;">☐ Countersink</td> <td style="border: none;">☐ Off-set</td> </tr> <tr> <td style="border: none;">☐ Heat Treat</td> <td style="border: none;">☐ Cut Too Short</td> <td style="border: none;">☐ Mislabeled</td> </tr> <tr> <td style="border: none;">☐ Wave/Twist in Tube</td> <td style="border: none;">☐ Instructions Incomplete/Unclear</td> <td style="border: none;">☐ Fit/Function</td> </tr> <tr> <td style="border: none;">☐ Marks/Chatter</td> <td style="border: none;">☐ Drill Holes</td> <td style="border: none;">☐ Misaligned/off center</td> </tr> </table>			☐ Crushing	☐ Countersink	☐ Off-set	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center
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OTHER : _____																																								



D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
02.09.14

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038451

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-436-0004
Fax: 416-736-0010

PO No: PO038451

PO Date: 11/22/17

Due Date: 12/13/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
DEC 05 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3690-1P			Glareshield As Per Dwg D3690 Rev. C	Firmed	12/13/17	3 pcs	0 pcs 3x	3 pcs	\$220.00/pcs As 18/02/05	\$660.00

Line Item Note job # 168641

Grand Total: \$660.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

CL
ALB

Plex 12/5/17 10:37 AM dart.baker.diane

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 38451 SO # 021408

Part #	<u>D3690-1P</u>	Qty.	<u>3</u>	Batch #	<u>-001</u>
Description	<u>GLARESHIELD ASSEMBLY</u>	Material usage	<u>5 SHTS</u>	Lot#	<u>M127208</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS
(Approved QA Signatory)

Date: JAN 30, 2018 COFC # 033

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐							
Date : 18-02-06		Step #: 150		QTY Effective : 53		MRB (QSI042) Approval					
Description Work Order Deviation				Disposition		PD 18-02-08					
Found at inspection that glove shield had extra holes on each side of top portion. See drawing for location. RC. cad file that was sent to the supplier was incorrect. No fault on supplier.				Scrap destroy Correct cad file one to be sent to supplier in order to replace the scrap one. See attach Email		Completed By					
						Lead hand / Supervisor Approval Verification					
						QC / QA Coordinator Approval					
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☒ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Patrick Duval

From: Robert Aboud
Sent: Wednesday, February 07, 2018 3:24 PM
To: Chris Provencal; Linda Lacelle; Patrick Duval
Cc: Jean-Luc Menard; David Shepherd
Subject: RE: Shipping date / DART1387 / Helicentro

It worked, they've got it

Rob Aboud

Director of Supply Chain
DART AEROSPACE
T 1-613-632-5200 Ext.244
M 1-514-979-6138
www.dartaerospace.com



From: Chris Provencal
Sent: Wednesday, February 07, 2018 3:16 PM
To: Robert Aboud <raboud@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Robert,

I've used your link to a shared link for the necessary file:

<https://drive.google.com/open?id=1Or4gugHK0H86E6j7ZFFEIbjyNjvUOdj1>

Chris

From: Robert Aboud
Sent: Wednesday, February 07, 2018 3:05 PM
To: Chris Provencal <cprovencal@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Ok I've asked Plastech to start reforming qty 3 and to provide a completion date ASAP

Rob Aboud

Director of Supply Chain
DART AEROSPACE
T 1-613-632-5200 Ext.244
M 1-514-979-6138
www.dartaerospace.com



From: Chris Provencal

Sent: Wednesday, February 07, 2018 2:55 PM

To: Linda Lacelle <llacelle@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Robert,

I've corrected the CAD file in the vault and removed the holes that shouldn't be there (/3D Data/D3600 Series/D3690/Outsource Data). To summarize the change: the D3690-1 Glareshield should have no holes except for the qty(4) 0.375" holes shown on sheet 3 of D3690 Rev. C.

The file is too large to attach to an email (53MB), we need to get that file to Plastec for use with all future Glareshields. We might have to FedEx a USB drive or use a file sharing service.

Chris

From: Linda Lacelle

Sent: Wednesday, February 07, 2018 2:49 PM

To: Robert Aboud <raboud@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Thx Rob, these would need to be in early next week

From: Robert Aboud

Sent: Wednesday, February 7, 2018 2:48 PM

To: Linda Lacelle <llacelle@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Checking with Plastech if they have material to rerun quickly

Rob Aboud

Director of Supply Chain

DART AEROSPACE

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com



From: Linda Lacelle
Sent: Wednesday, February 07, 2018 1:41 PM
To: Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; Robert Aboud <raboud@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro
Importance: High

This is going to cause a HUGE problem for the customers! They have already been pushed out twice! I am sure Plas-Tech will not be able to ship more next week, which would be a THIRD time pushing out the dates on the customers! Can we not at least push 3 through?? I am sure we will loose these orders, as well as piss off the customers!

L

From: Chris Provencal
Sent: Wednesday, February 7, 2018 1:36 PM
To: Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Linda,

The CAD file we provided the supplier was incorrect and shows holes that are meant to be drilled by the customer upon install. This was an error by engineering.

The presence of these holes may cause a compatibility issue for the customer and I recommend we scrap the parts. I've deleted the CAD file in the vault and will create a new CAD file to send to the customer. I want to confirm some information with Pat before releasing the new file.

Chris

From: Linda Lacelle
Sent: Wednesday, February 07, 2018 12:12 PM
To: Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: FW: Shipping date / DART1387 / Helicentro
Importance: High

D3690 Glare shields – have we decided if these are acceptable or not?? I need to let the customers know if they are going to be late

L

From: Oscar Martinez
Sent: Wednesday, February 7, 2018 12:10 PM
To: Linda Lacelle <llacelle@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>
Subject: Shipping date / DART1387 / Helicentro

Hi team,

Could you please let me know if we are still on time to ship order DART1387. Promise ship date was for this week. Could you please confirm and provide ship date?